

Date: Thursday, 01/05/2008 11:56:53 AM  
 User: dulf Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 38941	Part Number	: D35371
Estimate Number	: 12712	Drawing Number	: D3537 REV C
P.O. Number	:	Project Number	: N/A
This Issue	: 01/05/2008 S.O. No. :	Drawing Revision	: C
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 10/05/2008 Qty: 100 Um: Each
Previous Run	: 38254		
Written By	:		
Checked & Approved By	: <u>JUL 08-5-01</u>		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 
		Comment: Qty.: 0.1113 sf(s)/Unit Total : 11.1300 sf(s) M304S16GA .063" 304 SS SHEET Batch: <u>107772</u> <u>FB 8-5-5</u>
2.0	WATER JET	FLOW WATER JET 
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <u>C</u> <u>FB 8-5-5</u> Prog Rev: <u>C</u>
		2-Deburr if necessary <u>FB 8-5-5</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK <u>08/05/05</u> <u>(X19)</u> <u>cants</u>
5.0	BRAKE NC	NC BRAKE 
		Comment: NC BRAKE 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1



Date: Thursday, 01/05/2008 11:56:53 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 38941

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
2059B Hardcoat M106834 + M108631  
1- per Dwg D35371 using Jig DT 8210  
2- Remove any weld that penetrated through Wearpadif necessary

119-72-47  
LZ (47) 8-8-14  
8808/06/20 72x

M0 QC10

VISUAL INSPECTION OF GROUND WELDS



J0808-14 (47)



Comment: VISUAL INSPECTION OF GROUND WELDS

8.0 QC5

INSPECT WORK TO CURRENT STEP



J08/08/14 (47)



Comment: INSPECT WORK TO CURRENT STEP

9.0 POWDER COATING

POWDER COATING



M106442



(47X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:00

00:00

OVEN TEMPERATURE: 320°

00:00

FINISH TIME: 10:30

m.f 08/08/18

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



BK



(47)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 PACKAGING 1

PACKAGING RESOURCE #1



08-08-18

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

BK 08-08-18

(47)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/19 JJ

Comment: FINAL INSPECTION/W/O RELEASE

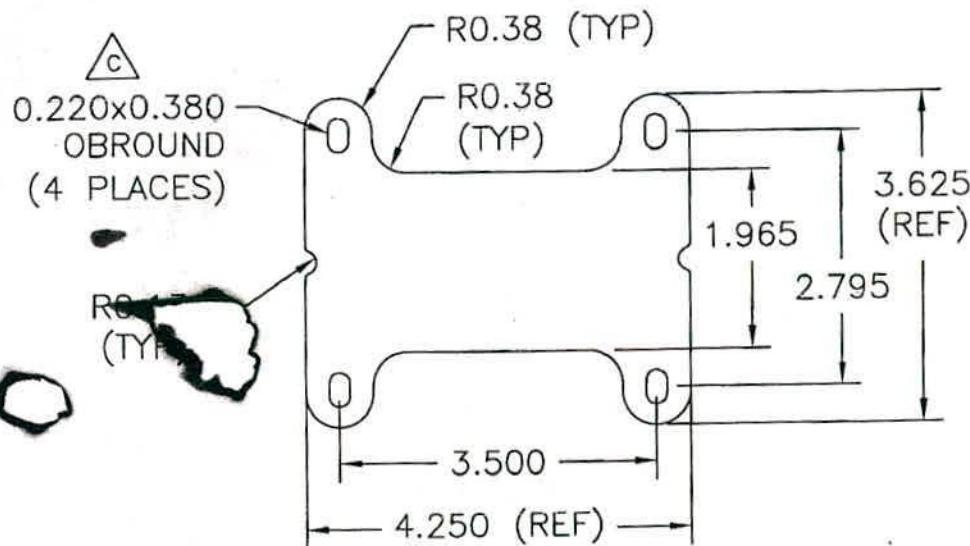
Job Completion



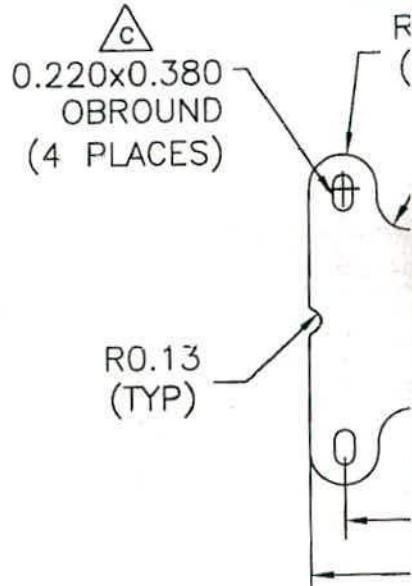
MF 08-08-18



### D3537-1F FLAT PATTERN

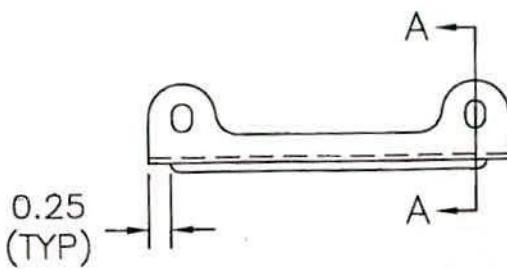


D35



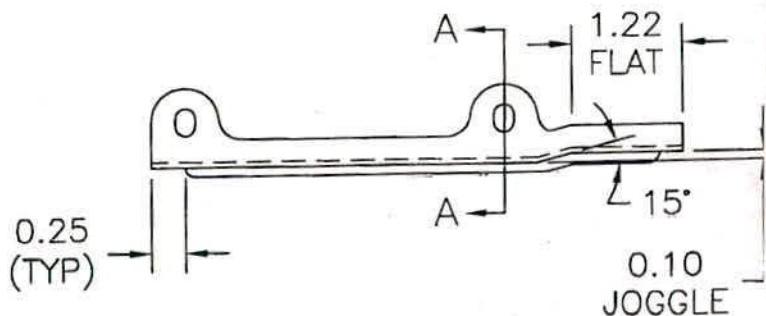
### D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



### D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)

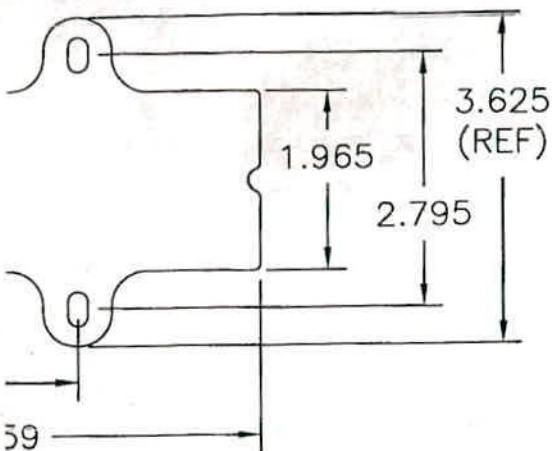


### D3537-1/-3/-5/-7 WEARPAD NOTES

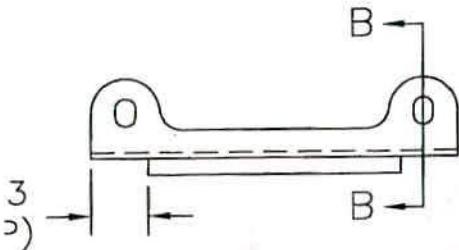
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 (REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



AT PATTERN



D3537-5 LONGITUDINAL BEND  
(MADE FROM D3537-1F)



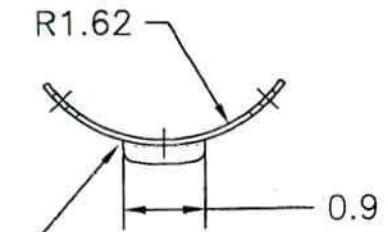
.063 THICK)

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.

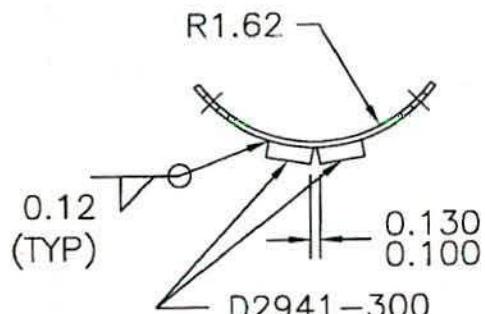
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE USA, INC.

SECTION A-A



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

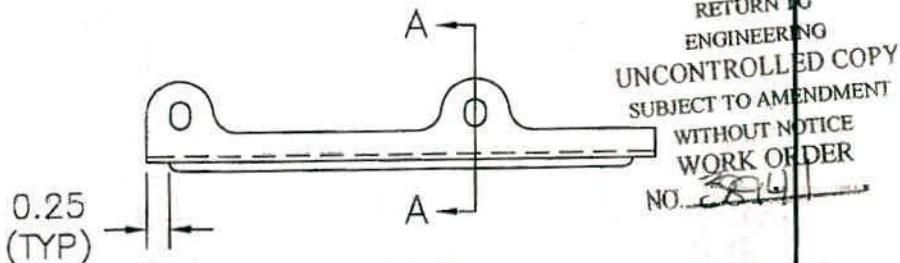
SECTION B-B



D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

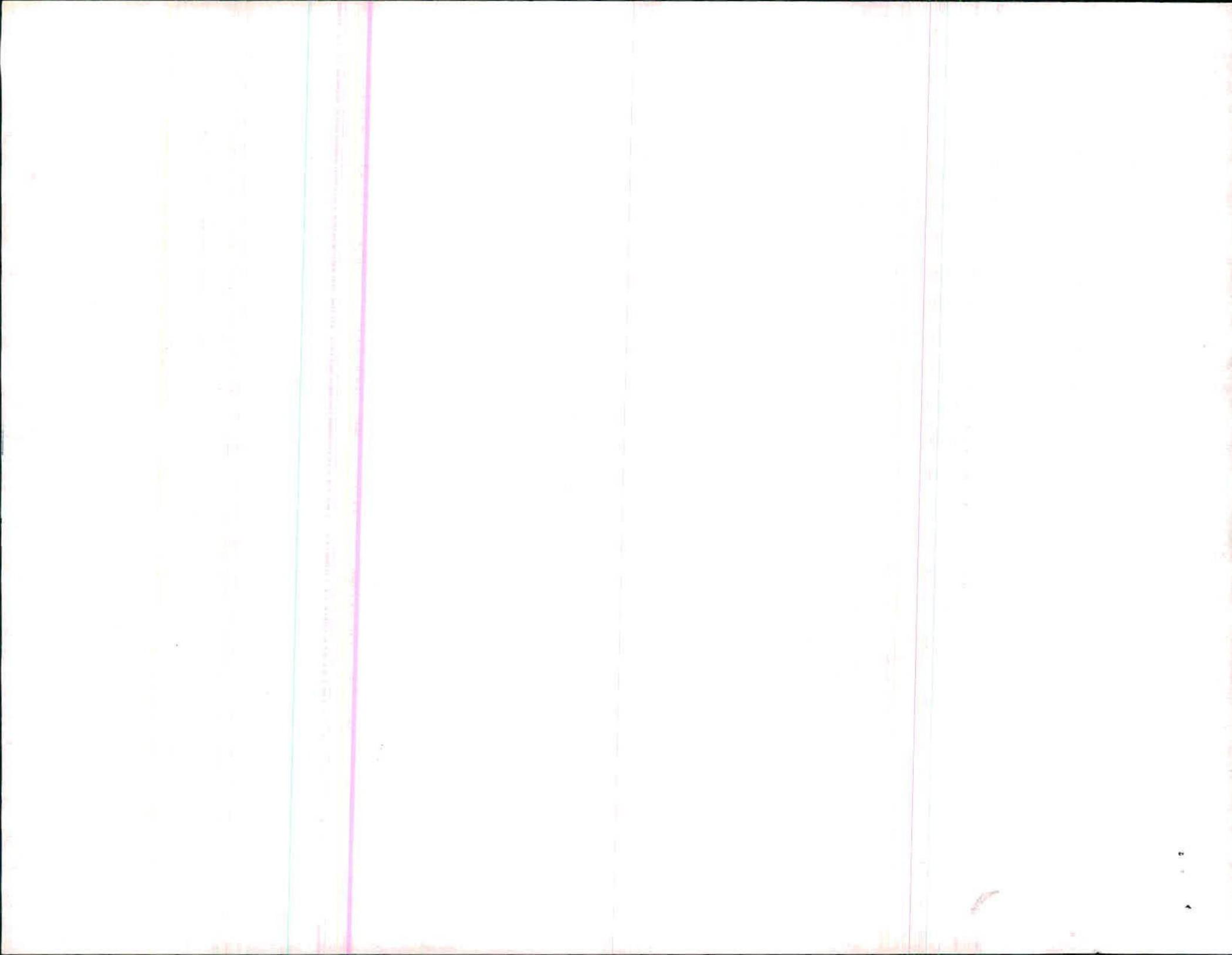
**RELEASED**  
07.05.08 AM  
per E&LN  
952

D3537-7 LONGITUDINAL BEND  
(MADE FROM D3537-3F)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 5814

DESIGN	DRAWN BY	DART	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	PH	DART	REV. C
CHECKED	APPROVED	DRAWING NO. D3537	SHEET 1 OF 1
DATE		TITLE WEARPAD	SCALE 1:2
07.04.13			



DART AEROSPACE LTD

Work Order: 39941

Description: WEAR PAD

Part Number: D 3537-1

Inspection Dwg: DR531-1 Rev: C

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article

## Prototype

Measured by

18

**Audited by:**

---

**Prototype Approval:**

1

### Dates

१-५-५

Date:

Date:

六

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

10

